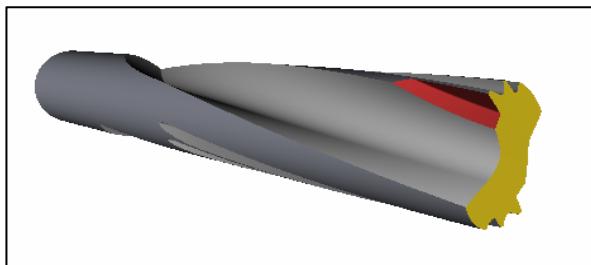


Reamer Ø14 Z2

A01-011

Due to the geometry of the tool Flute 2, Flute 3 and Flute 4 operations are ground with a 11V9 wheel defined spindle side



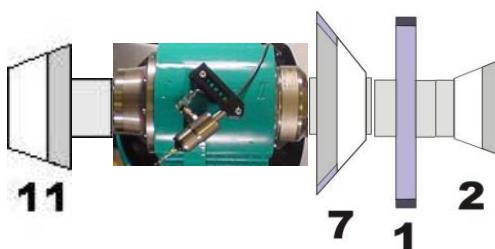
1. Cycletime for Production

Workpiece:	Diameter 14 mm, Z 2, Length of cutting edge 130 mm, Helix angle 10° Material: Carbide						
Operations							
Feed [mm/Min]	2000	80	100	100	100	100	100
Power [kW]		9	4	5	5	5	5
Cutting feed [m/s]		32	32	32	50	50	
Used wheels							
Grinding time [s]	6	235	46	20	192	192	192
Total cycle time	14 Min 41						

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1A1 Ø100 B106
2	11V9 Ø75 B106
7	12V9 Ø125 B106
11	11V9 Ø100 B106



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG

Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 160i

Software: Quinto 5

Accessories:

Responsable engineer: SBA, 18.11.09

www.schneeberger.ch

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